

Date: Monday, 10/11/2008 10:43:50 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW RING
Job Number	: 43274 - 2	Part Number	: D3407045
Estimate Number	: 13456	Drawing Number	: D3407
P.O. Number	:	Project Number	: N/A
This Issue	: 10/11/2008 S.O. No. :	Drawing Revision	:
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : LARGE FAB ASSY	Due Date	: 21/11/2008
Previous Run	: 42438	Qty:	30
Written By	:	Um:	Each
Checked & Approved By	: <u>JLD 08.11.10</u>		
Comment	: Est Rev:A New Issue 08-07-09 JLM Verified by:EC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D34075

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3407-5

Ring B43344

X12

EL 8-12-8 X12

2.0

D34077

TOW RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

TOW RING

B43834

X12

EL 8-12-8 X12

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3407--5 and D3803-1 using welding rod TIG174 as per Dwg D3803 &amp; QSI 004

A/R TIG174 ROD

Batch: P1101972

X12

EL 8-12-8 X12

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cp 08.12.08

EL 08.12.08

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08.12.08 (X12)

Date: Monday, 10/11/2008 10:43:50 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 43274

Part Number: D3407045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 102316



12x

Comment: POWDER COATING

~~Powder Coat White Gloss~~ (Ref: 4.3.5.1) as per QSI 005 4.3  
SANITEX GREEN

\*\*Mask Threaded Section\*\*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11 = 00  
01  
320  
11 = 30

M-1 08/12/15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-15

X 12

8.0

PACKAGING 1

PACKAGING RESOURCE #1



12x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Store

8/12/15

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/16

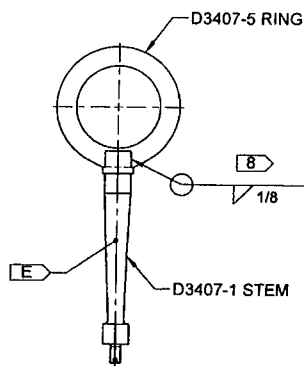
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

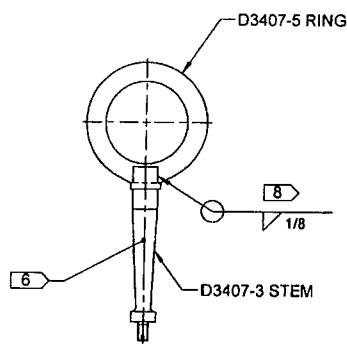


u 08/12/16

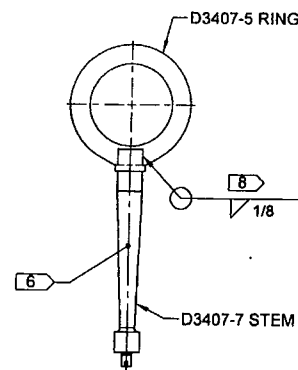
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



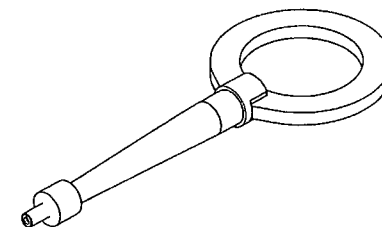
**D3407-041 TOW RING**



**D3407-043 TOW RING**





**D3407-045 TOW RING**

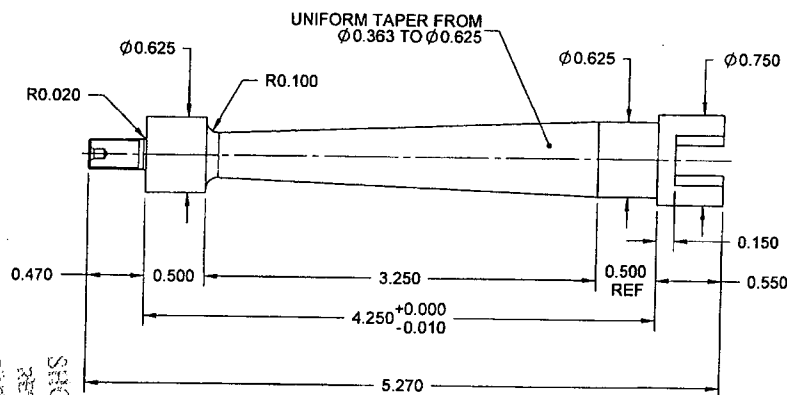
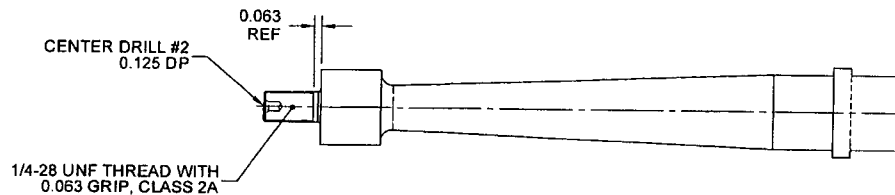


**RELEASED**

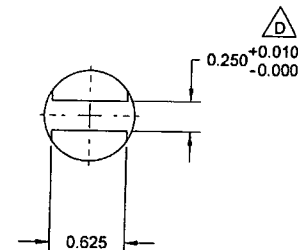
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WITHOUT NOTICE  
WORK ORDER  
NO. 413874

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
  - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN DRAWN		<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3407	REV. E
MFG. APPR.			SHEET 1 OF 5
APPROVED		TITLE TOW RING	SCALE NTS
DE APPR.			
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**D3407-1 STEM**

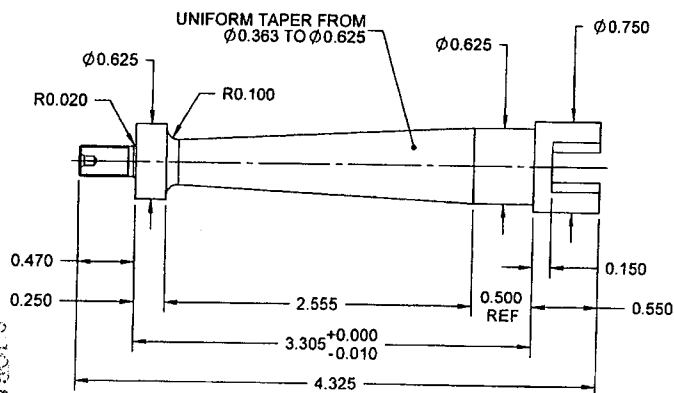
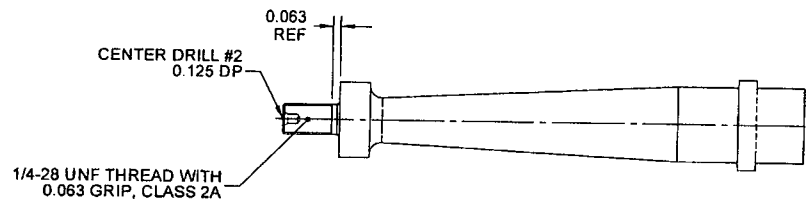


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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
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DE APPR.		TOW RING	NTS
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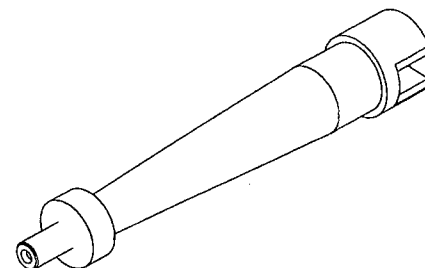
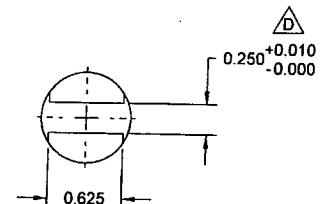
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.33 lbs

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**D3407-3 STEM**

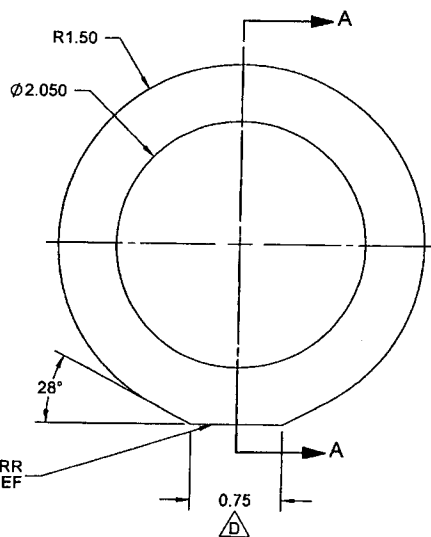


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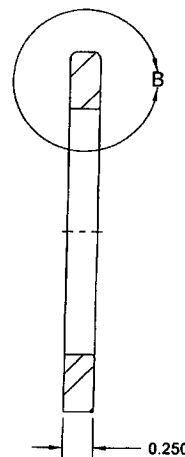
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

**RELEASED**  
01-08-01-118

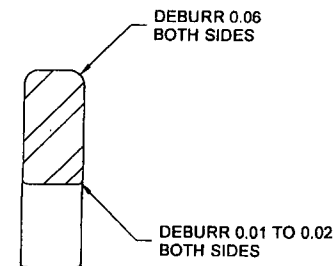
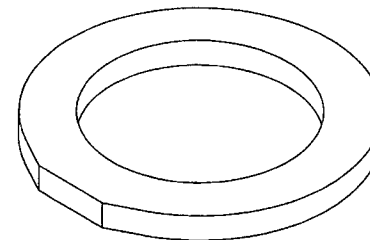
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MFG. APPR.		D3407	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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**D3407-5 RING**



**SECTION A-A**



**DETAIL B  
SCALE 2X**

**RELEASED**  
08-07-23

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

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DE APPR.		<b>TOW RING</b>	NTS
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8

7

6

5

4

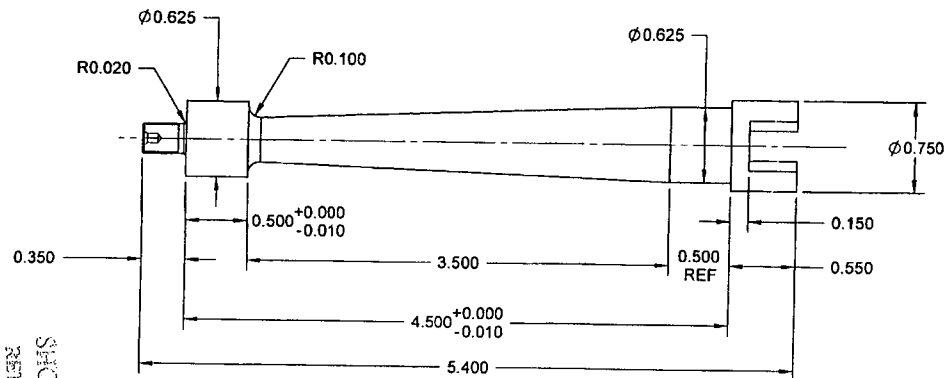
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2

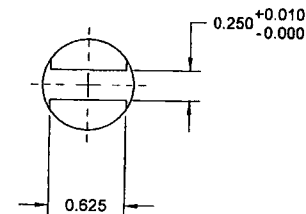
1

0.063  
REF  
CENTER DRILL #2  
0.125 DP

1/4-28 UNF THREAD WITH  
0.063 GRIP, CLASS 2A






**D3407-7 STEM**



**RELEASED**

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.34 lbs

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